

Work Order ID 50968 - 2

July 28, 2009 11:48:04 AM



Page 1

Item ID: D3011-1

Revision ID: B

Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00

Required Date: 05/08/2009 Req'd Qty: 10.00

Reference: 31/07/2009

Split - 1

Accept



Setup Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
----------	--------------	--

D3011	Rev B	
-------	-------	--

100	BAND SAW	0.00	10						
-----	----------	------	----	--	--	--	--	--	--

	Memo	0.00							
--	------	------	--	--	--	--	--	--	--

	Cut Blanks: 26.625"								
--	---------------------	--	--	--	--	--	--	--	--

H A 09/07/28

110	HAAS CNC VERTICAL MACHINING #1	0.00							
-----	--------------------------------	------	--	--	--	--	--	--	--

	Memo	0.00							
--	------	------	--	--	--	--	--	--	--

	Machine as per folio FA129								
--	----------------------------	--	--	--	--	--	--	--	--

Folio Rev: B

Dwg Rev: B

H A 09/08/01

8809/08/09

6

Work Order ID 50968

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Page 2

Item ID: D3011-1

Revision ID: B

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Start Date: 31/07/2009 Start Qty: 10.00

Accept



Setup

Start



Stop



Required Date: 05/08/2009 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120
Barcode
QC
Quality Control

130
Barcode
QC
Quality Control

131
Barcode
Outsource2
Outsource process - NDT

Memo

0.00

1/1 09/08/01

QC8- Inspect parts - second check

0.00

1/1 09/08/05

Memo

0.00

0.00

Memo

0.00

LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG d3011

P10.10194
P10.10205

Rec'd + attached report

C4 09/08/11 (10)

C2 09/08/12 5

C4 09/08/11 10
C2 09/08/12 5

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Item ID: D3011-1

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Start Date: 31/07/2009 Start Qty: 10.00

Required Date: 05/08/2009 Req'd Qty: 10.00

Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID



Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

ML 09-08-12



Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

ML 09-08-15 X5



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

11112260

0.00

START TIME: 2:30pm
OVEN TEMPERATURE: 320°
FINISH TIME: 2:30pm

ML 09-08-15 X5

Work Order ID 50968
, 28, 2009 11:48:04 AM



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Item ID: D3011-1
Revision ID: B
Item Name: Rappel
Start Date: 31/07/2009 Start Qty: 10.00
Required Date: 05/08/2009 Req'd Qty: 10.00



Setup

Start



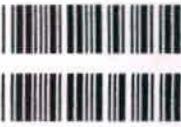
Stop

Cust Item ID:

Customer:

Run

Start



Stop

Process Plan: _____
QC: _____

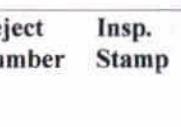
Date: _____
Date: _____

Tooling: _____
SPC (Y/N): _____

Date: _____
Date: _____

Run

Start



Stop

Sequence ID/
Work Center ID

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

10613

Draw
Rev.

1

Plan
Code

1

Accept
Qty

10

Reject
Qty

0

Reject
Number

1

Insp.
Stamp

1

160
QC
Quality Control

Memo

0.00

~~09/08/24~~

(X5)

f

170
Packaging
Packaging

Memo

0.00

09/08/24 2 stn
3 Assy.

180
QC
Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/08/25

5 Bl 09-8-24

DART AEROSPACE LTD	Work Order: 50968
Description: Rappel	Part Number: D3011
Inspection Dwg: D3011 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

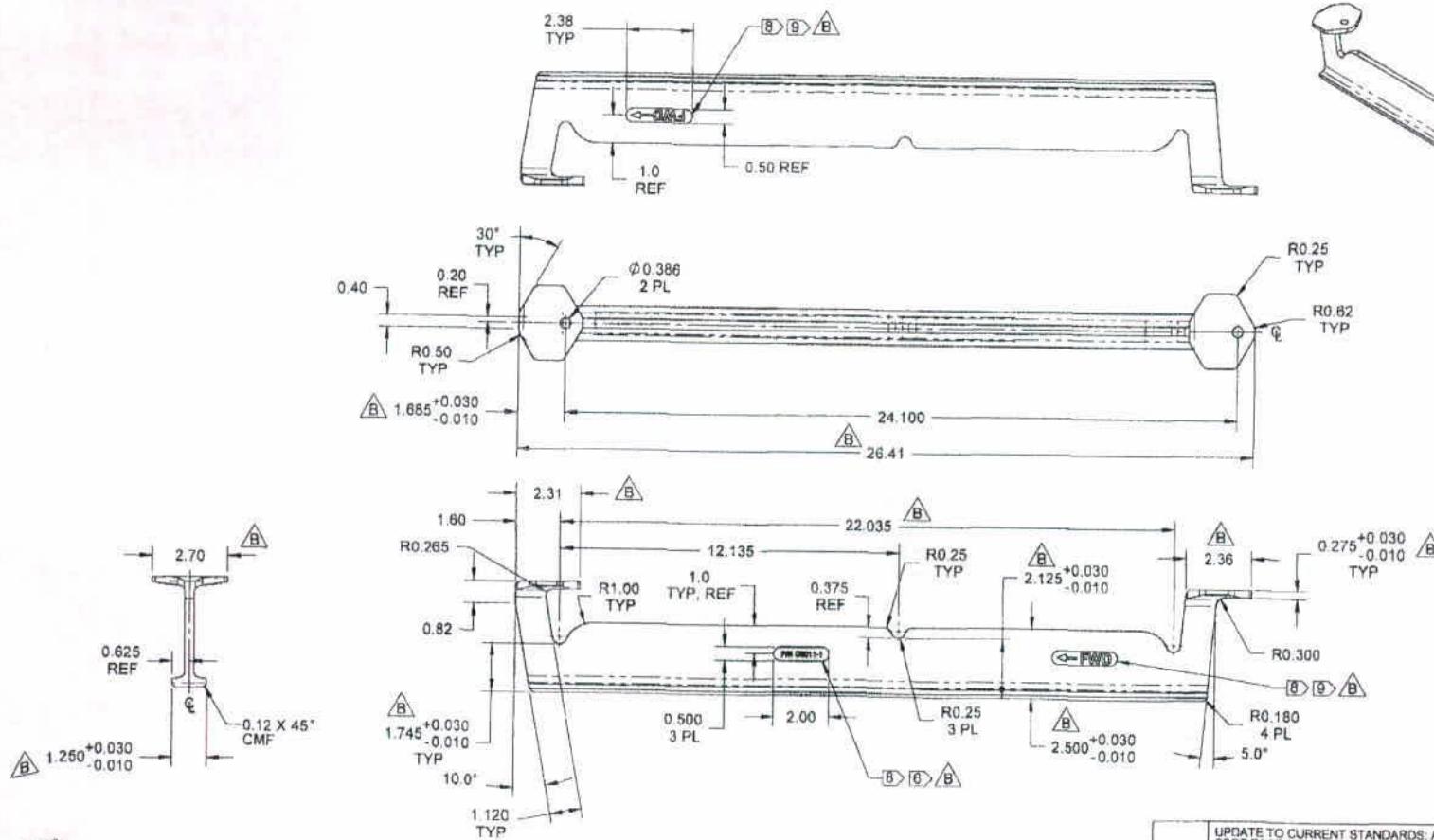
X First Article Prototype

Measured by:	J. A
Date:	09/08/02

Audited by:	SL
Date:	09/08/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6202-027 EXTRUSION
- 2) FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PIN IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.015 IN 0.19 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 3.00 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING
- 9) ENGRAVE "FWD" IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.015 IN
0.38 HIGH LETTERS WITH MIN TOOL RADIUS OF 0.015
- 10) LPI PER ASTM 1417 LEVEL 2

D301

D3011-1 RAPPEL SLIDE BAR

B	UPDATE TO CURRENT STANDARDS; ADD NOTE 8; ADD SPOT FACE (ZN B2-1, B4-1 & D5-1); ADD DIMENSIONS (ZN B3-1, B4-1 & C5-1); 26.41 WAS 26.32 (ZN C4-1); 2.70 WAS 2.700 (ZN B7-1); ADD (+0.030/-0.010) TOLERANCES; ADD LPI (ZN A6-1)			RF	09.07.24
A	NEW ISSUE			CP	01.03.29
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>B</i>	DRAWING NO.	REV. B		
MFG. APPR.	<i>SJ</i>	D3011	SHEET 1 OF 1		
APPROVED	<i>AS</i>	TITLE	SCALE		
DE APPR.	<i>AS</i>	RAPPAL SLIDE BAR			NTS
DATE	09.07.24	COPYRIGHT © 2001 BY DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED. PRINTED/GENERATED FROM DART AEROSPACE LTD.			

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LIQUID PENETRANT TEST REPORT

P. 14945

CLIENT Dart Aerospace DATE Aug-10-2009 PAGE 1 OF 1
 ATTENTION LINDA / CHANTAL TIME AM PM
 ADDRESS 1270 ABERDEEN ST.
 PROJECT F.P.I. ON MACHINED PARTS - ACCEPTANCE STD. ASME 1417 REV./DATE 2007
 ITEM(S) EXAMINED 44 STUDS. + 20 RAPPELS + 7 CROSS TUBES. + 12 STUDS.

JOB DESCRIPTION PROCEDURE NO. LT-0002 REV./DATE * TECHNIQUE NO. LT-TECH 2 REV./DATE
 PART NO. MATERIAL STAINLESS STEEL THICKNESS 1/4 INCH
 SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION CALLED OUT 100% EXTERNAL

TEST DETAILS
 METHOD FLUORESCENT VISIBLE WATER WASH SOLVENT REMOVABLE POST EMULSIFIED
 FAMILY BRAND MAGNAFLUX
 PENETRANT ZL 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. FLASHLIGHT TROUBLELIGHT OUTPUT > 1000 μ W/cm² AMBIENT < 2 fc
 PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LAB INC
 DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N
 DEVELOPER TYPE NON AQUEOUS AQUEOUS DRY CAL DUE DATE
DEC. 8 - 2009

TEST SURFACE
 SURFACE CONDITION AS GROUND AS WELDED MACHINED SHOT BLASTED CLEAN BARE METAL
 SURFACE TEMPERATURE < -4°C/ 20°F -4°C/ 20°F TO 10°C/ 50°F 10°C/ 50°F TO 52°C/ 125°F > 52°C/ 125°F

RESULTS- METRIC IMPERIAL

14 Pcs STUDS - W.O. 509 33	✓	To Buff and Examine - Indication - 6 items to examine after Buffing - Other Pcs found acceptable to standard.
30 Pcs STUDS - W.O. 507 21	✓ x 0	
12 Pcs STUDS - W.O. 509 32.	✓	
10 Pcs RAPPEL - W.O. 509 67	✓	
10 Pcs RAPPEL - W.O. 509 68	✓ x (5)	
1 CROSS TUBE - W.O. 510 83	✓	
1 CROSS TUBE - W.O. 510 84	✓	
1 CROSS TUBE - W.O. 510 85	✓	
1 CROSS TUBE - W.O. 508 73	✓	
1 CROSS TUBE - W.O. 508 27	✓	
1 CROSS TUBE - W.O. 508 00	✓	
1 CROSS TUBE - W.O. 508 26	✓	

Scope of Services
 The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
 In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE <u>Chantal Lauden</u> PRINT <u>219</u>	SIGNATURE <u>Chantal Lauden</u>	DTR # <u>E - 20068</u>
TECHNICIAN (SIGNATURE): <u>Mike Johnson</u>	REPORT REVIEWED BY:	
NAME (PRINT): <u>Mike Johnson</u>	NAME <u></u>	INITIALS <u></u>
CGSB LEVEL <u>X</u> SNT LEVEL CGSB REG. NO. <u>6066</u>	2 nd TECHNICIAN CGSB LEVEL _____ SNT LEVEL _____ CGSB REG. NO. _____	



LIQUID PENETRANT TEST REPORT

P- 14946

CLIENT	DART AEROSPACE			DATE	Aug 12-2009		
ATTENTION	LINDA/CHANTEL			ACUREN JOB NO.	188-09-001485		
ADDRESS	1270 ABENDEEN ST. ON.			PO/WO NO.	- 10205		
PROJECT	F.P. I. ON MACHINED PARTS AND			WORK LOCATION	HAWKESBURY - ON.		
ITEM(S) EXAMINED	Gloss Tubes - EXAMINE - W.O. 50721 - ONE STUD, W.O. 50868 - 5 PAPERS			ACCEPTANCE STD.	ASTM 1417 REV./DATE 2007		
JOB DESCRIPTION	PROCEDURE NO. LT 0002 REV./DATE			TECHNIQUE NO. LT Tech 6 REV./DATE			
PART NO.				MATERIAL	STAINLESS STEEL THICKNESS 1/4 INCH		
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL						
TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	MAGNAFLUX			BLACK LIGHT S/N 16459	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc	
PENETRANT	2L67	MINIMUM DWELL TIME	85s	MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER	420	MINIMUM DRY TIME	>10	MIN.	OTHER	CAL DUE DATE	
DEVELOPER	SKD 52	MINIMUM DWELL TIME	10	MIN.	LIGHT METER S/N	DEC 8 - 2009.	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY				
TEST SURFACE							
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input checked="" type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL		
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F		<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F		
RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)							
1 - STUD, W.O. 50721	✓	ITEM WAS BUFFED- AND FOUND. ACCEPTABLE					
5 - PAPER, W.O. 50968	✓	ITEMS WERE BUFFED- AND FOUND. ACCEPTABLE					
1 - GLOSS TUBE, W.O. 50801	✓	- WORK ORDERS EXAMINED ON THIS REPORT HAVE BEEN FOUND ACCEPTABLE TO SET STANDARD.					
1 - GLOSS TUBE, W.O. 50877	✓						
12 - STUDS, W.O. 50721	✓						
ML 09 08 12							

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SIGNATURES

CLIENT REPRESENTATIVE	Ron Titley PRINT	<i>Ron Titley</i> SIGNATURE	DTR #	E-20069	
TECHNICIAN (SIGNATURE)	<i>RJ</i>		REPORT		
NAME (PRINT)	Mike Johnson		REVIEWED BY:		
CGSB LEVEL	II	SNT LEVEL	2 nd TECHNICIAN	NAME	
CGSB REG. NO.	6006		CGSB LEVEL	INITIALS	
CGSB REG. NO.			SNT LEVEL		

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY